

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021966**Date Inspected:** 02-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 14

This QA Inspector randomly observed the following work in progress in the Bay 14:

SMAW repair welding of weld joints DP3163-001-026, 027 located on PCMK OBG 14E. Welder was identified as 215553. QC was identified as ABF Bao Qian (QC1), who was not a CWI. Assisting QC1 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Zhao Hai Feng (QCA1), who was not a CWI. Weld variables recorded by QCA1 appeared to comply with WPS-345-SMAW-2G(2F)-FCM-repair as displayed on ZPMC Weld Repair Report B-WR20222 presented to this QA Inspector and verbally identified by QCA1.

FCAW welding of weld joints SA3174-001-009, 013, 021, 110 located on PCMK OBG 13AW. Welder was identified as 045175. QC was identified as ZPMC QC Shi Lei (QC2), who was not a CWI. Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ABF QC Chen Kun (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-T-2232-ESAB and WPS-B-T-2233-ESAB as verbally identified by QCA2.

SMAW repair welding of weld joint SA7512C-257 located on PCMK OBG 13W. Welder was identified as 045196. QC was identified as ABF CWI Li Shi You (QC3). Assisting QC3 at this location and appearing to be

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monitoring the welding operation and recording data was ZPMC QC Zhu Lin (QCA3), who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-345-SMAW-4G(4F)-FCM-repair-1 as displayed on ZPMC Weld Repair Report B-CWR2629 presented to this QA Inspector and verbally identified by QCA3.

SMAW welding of weld joint SEG3013AH-128 located on PCMK OBG 13AW. Welder was identified as 047864.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

SMAW welding of weld joint SEG3013AH-126 located on PCMK OBG 13AW. Welder was identified as 067764.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

SMAW welding of weld joint SEG3013H-360 located on PCMK OBG 13AW. Welder was identified as 066079.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

SMAW welding of weld joint SEG3013AH-124 located on PCMK OBG 13AW. Welder was identified as 066361.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1 as verbally identified by QCA3.

FCAW welding of weld joint SEG3013M-035 located on PCMK OBG 13AW. Welder was identified as 067876.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013P-061 located on PCMK OBG 13AW. Welder was identified as 068445.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013R-026 located on PCMK OBG 13AW. Welder was identified as 066421.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joint SEG3013M-006 located on PCMK OBG 13AW. Welder was identified as 069469.

QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2232-ESAB as verbally identified by QCA3.

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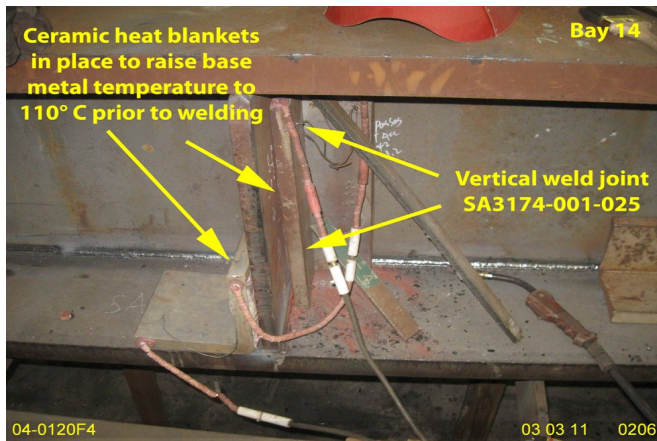
SMAW welding of weld joint FB3317-001-146 located on PCMK OBG 14W. Welder was identified as 067609. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-P-2214-FCM-1 as verbally identified by QCA3.

FCAW welding of weld joint SEG3020LL-589 located on PCMK OBG 14W. Welders were identified as 067949. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

FCAW welding of weld joints SA3174-001-009, 013, 025 located on PCMK OBG 13AW. Welder was identified as 207465. QC was identified as QC3, who was not a CWI. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2232-ESAB and WPS-B-T-2233-ESAB as verbally identified by QC3. See photo below of base metal being preheated prior to start of welding weld joint SA3174-001-025.

FCAW welding of weld joints DP3128-001-019, 029, 043, 057 located on PCMK OBG 14W. Welder was identified as 215676. QC was identified as QC3. Assisting QC3 at this location and appearing to be monitoring the welding operation and recording data was QCA3, who was not a CWI. Weld variables recorded by QCA3 appeared to comply with WPS-B-T-2233-ESAB as verbally identified by QCA3.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer